

Thursday, December 20, 2012 1:55:21 PM

**\*94866\***

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**Accept**

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Item Name:** Expandable Pin Assembly, Modified

**Start Date:** 12/20/2012    **Start Qty:** 4.00    **\*4\***

**Cust Item ID:**

**Required Date:** 12/21/2012      **Req'd Qty:** 4.00      **\* 1 \***

**Customer:**

**Reference:**

**Approvals:**

### Process Plan:

Date:

### Tooling:

Date:

Run Start \*NR1\*

**QC:**

**Date:**

**SPC (Y/N):**

**Date:**

Stop \*NR2\*

[illegible]

**\*94866\***

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**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Start Date:** 12/20/2012    **Start Qty:** 4.00    **\*4\***

**Cust Item ID:**

**Required Date:** 12/21/2012      **Req'd Qty:** 4.00      **\* 1 \***

**Customer:**

**Reference:**

**Approvals:** \_\_\_\_\_ **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

## Operation Description

## Set Up/ Run Hours

## Tool ID

## Tool #

## Plan Code

**Accept**

**Qty**

Reject  
Qty

## Reject Number

## Insp. Stamp

140

Identify as per dwg & Stock Location: (9A

0,00

\*140\*

## Packaging

## Memo

u/o 94865

0.00

## Packaging

150

QC21- Final Inspection - Work Order Release

0.00

**\*150\***

QC

## Memo

0.00

## Quality Control

13/1/11A

mf  
12-12-21

## Picklist Print

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**Work Order ID: 94866**

**Parent Item: D4711-041****Start Date:** 12/20/2012

**Required Date:** 12/21/2012.

**Parent Item Name:** Expandable Pin Assembly, Modified

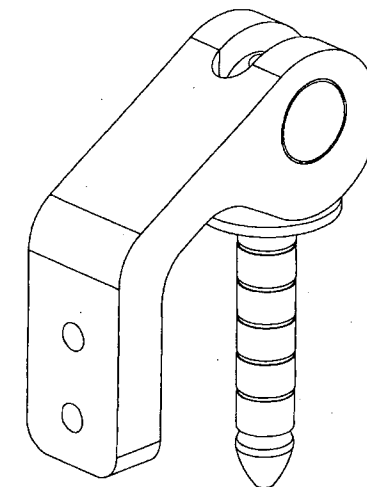
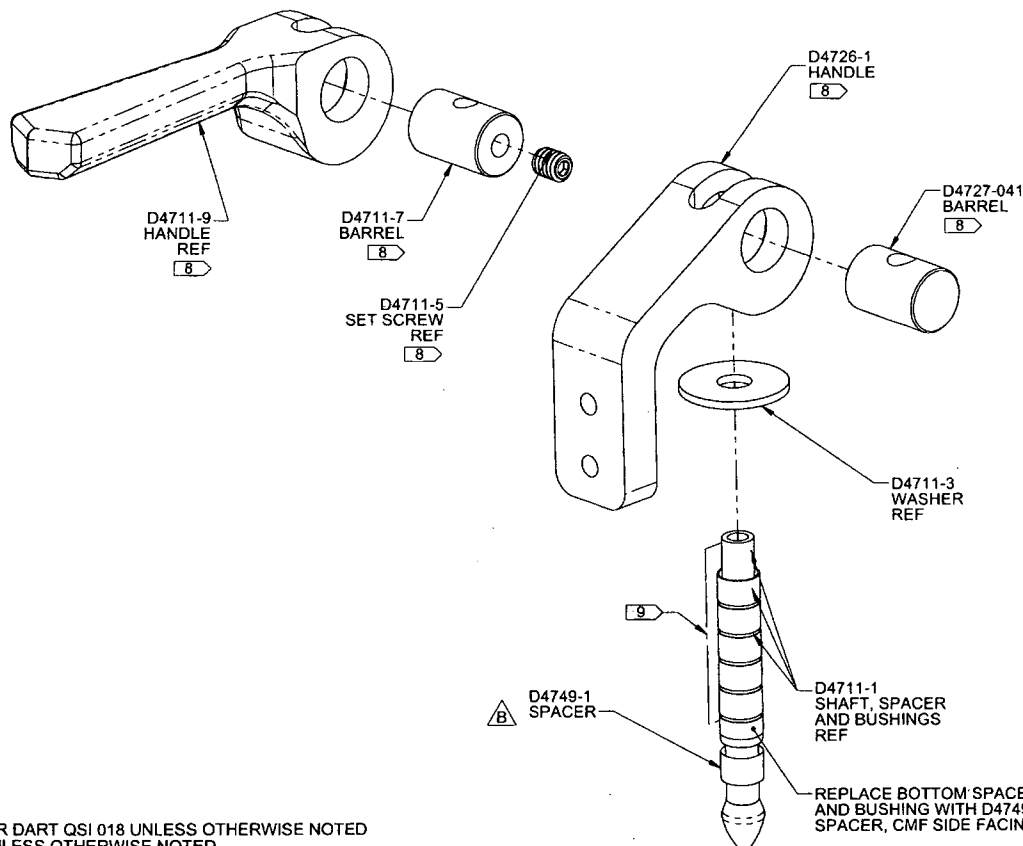
**Start Qty: 4.00**

**Required Qty: 4.00**

**Comments:** IPP REV:A 12.10.16 AS PER DWG REV.A DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4711-043 Expandable Pin Assembly		Manufactured	No				Each	0.0000		4		FF 12-12-21	
D4726-1 Handle		Manufactured	No				Each	2.0000		4		FF 12-12-21	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST119		2	B93677			4			
				92205		2							
D4727-041 Barrel		Manufactured	No				Each	8.0000		4		FF 12-12-21	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST119		8							
				92192		8							
D4749-1 Spacer		Manufactured	No				Each	0.0000		4		FF 12-12-21	

ITEM	QTY .041	P/N	DESCRIPTION
	X	D4711-041	EXPANDABLE PIN ASSY, MODIFIED
1	1	D4711-043	EXPANDABLE PIN ASSY
2	1	D4726-1	HANDLE
3	1	D4727-041	BARREL
4	1	D4749-1	SPACER



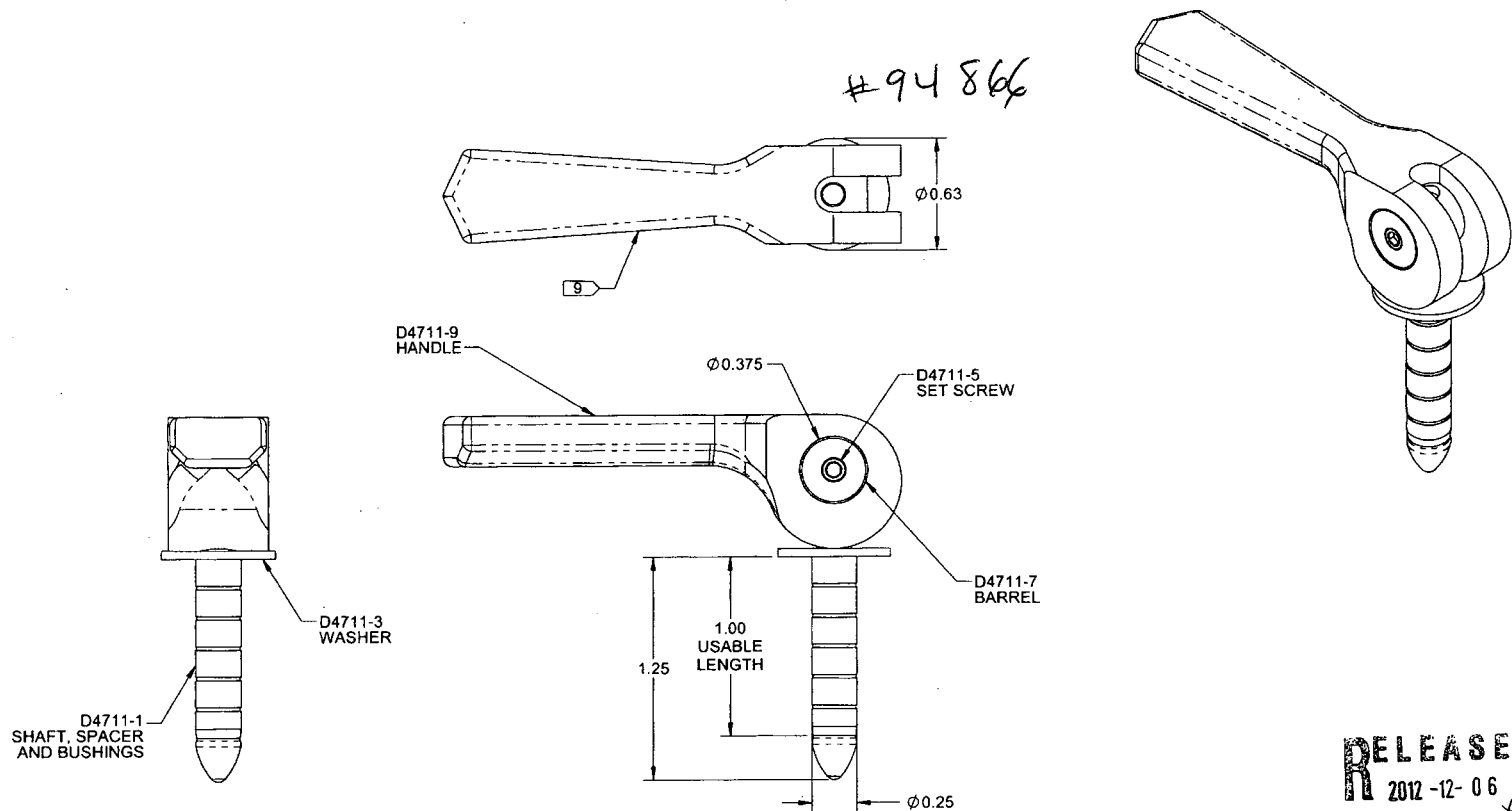
**D4711-041  
EXPANDABLE PIN ASSEMBLY, MODIFIED**

**RELEASED**  
2012-12-06

- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4711-041" AND B/N "BXXXXX" PER QSI 044 6.7
  - 7) WEIGHT: 0.19 lbs
  - 8) REPLACE D4711-9 HANDLE WITH DART D4726-1 HANDLE.  
REPLACE D4711-7 BARREL WITH DART D4727-041 BARREL.  
REPLACE BOTTOM BUSHING AND SPACER WITH D4749-1 SPACER.  
DISCARD D4711-5 SET SCREW, D4711-7 BARREL, D4711-9 HANDLE, BOTTOM BUSHING/SPACER.
  - 9) WHEN INSTALLING D4749-1 SPACER, ENSURE THAT ALL RETAINED SPACERS AND BUSHINGS REMAIN IN THEIR ORIGINAL SEQUENCE AND ORIENTATION.

B	ADDED D4749-1 SPACER, MODIFIED NOTES 8 AND 9	AP	12.11.23
A	NEW ISSUE	RP	12.09.19
REV.	DESCRIPTION	BY	DATE
DESIGN	RP	<b>DART AEROSPACE USA, INC.</b> KENT, WA	
DRAWN	RP		
CHECKED	RP	DRAWING NO.	REV. B
MFG. APPR.		D4711	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		ADJUSTABLE DIAMETER PIN	NTS
DATE	12.11.23	<small>COPYRIGHT © 2012 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

# **SPECIFICATION CONTROL DRAWING**



**D4711-043 EXPANDABLE PIN ASSY**

## **NOTES:**

- 1) MATERIAL: CORE PIN, SPLIT RINGS & BARREL: STAINLESS STEEL 17-4 PH CONDITION H925 PER AMS 5643
- 2) FINISH: N/A
- 3) TOLERANCES: N/A
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.14 lbs
- 8) RECOMMENDED SUPPLIER: MCMASTER CARR P/N 97787A661
- 9) HANDLE, BARREL AND SET SCREW TO BE DISCARDED AT NEXT HIGHER ASSEMBLY

DESIGN	RP	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	RP	KENT, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4711	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		ADJUSTABLE DIAMETER PIN	NTS
DATE	12.11.23	<small>COPYRIGHT © 2012 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	